

Work Order ID 71999

Friday, July 15, 2011 10:36:29 AM

Page 1

Item ID: D3684-045

Accept

Revision ID:

Item Name: LEG ASSEMBLY

Start Date: 7/15/2011 Start Qty: ~~2.00~~ ³

Required Date: 7/22/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3684

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

17 111 791

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

17 119 508

ensure holes AN3C bolts are clear of sealant

③ FF 12-04-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71999

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Item ID: D3684-045

Accept



Setup Start



Revision ID:

Stop



Item Name: LEG ASSEMBLY

Start Date: 7/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location <u>200</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

S. Taylor

B

12/4/5 30

12/4/5

1204-5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 71999

Parent Item: D3684-045

Parent Item Name: LEG ASSEMBLY



Start Date: 7/15/2011

Required Date: 7/22/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A Bolts		Purchased	No			110	Each	40.0000	2	4			
<div> <div>Location</div> <div>ST351 120423</div> <div>117514</div> <div>118112</div> </div> <div> <div>Loc Qty</div> <div>40</div> <div>4</div> <div>36</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3688-5 STUD		Manufactured	No			110	Each	1.0000	1	2			
<div> <div>Location</div> <div>B 72042</div> <div>79308</div> </div> <div> <div>Loc Qty</div> <div></div> <div></div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3689-1 SLEEVE		Manufactured	No			110	Each	0.0000	1	2			
<div> <div>Location</div> <div>B 72117</div> <div>78907</div> </div> <div> <div>Loc Qty</div> <div></div> <div></div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3691-1 STUD		Manufactured	No			110	Each	14.0000	1	2			
<div> <div>Location</div> <div>GA</div> <div>61370</div> <div>62181</div> <div>80363</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>3</div> <div>11</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

③ FF 12-04-03

6

③ FF 12-04-03

③ FF 12-04-03

③ FF 12-04-03

W/O:		WORK ORDER CHANGES					
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Work Order ID: 71999

Parent Item: D3684-045

Parent Item Name: LEG ASSEMBLY

Start Date: 7/15/2011

Required Date: 7/22/2011

Start Qty: 2.00

Required Qty: 2.00

D3692-1 Manufactured No

110 Each

131.0000

4

8



SPACER

B 73232



12 (3) FF 12-04-03

Location

Loc Qty

Loc Code

ST075

131

61

51467

131

D3693-1 Manufactured No

110 Each

12.0000

1

2



Rod. End Bearing

Location

Loc Qty

Loc Code

GA

12

73505

12

50734

80275

1

2

(3) FF 12-04-03

MS21043-3 Purchased No

110 Each

872.0000

2

4



Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

800

112314

65

118077

735

110614

6

(3) FF 12-04-03

NAS509-12C Purchased No

110 Each

18.0000

1

2



Nuts

Location

Loc Qty

Loc Code

ST280

18

279

112453

18

3

(3) FF 12-04-03

B

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Parent Item: D3684-045



Parent Item Name: LEG ASSEMBLY

Start Date: 7/15/2011

Required Date: 7/22/2011

Start Qty: 2.00

Required Qty: 2.00

NAS509L12C

Purchased

No

110

Each

23.0000

1

2



Nuts

③ FF 12-04-03

Location

Loc Qty

Loc Code

ST280

23

112314

13

112828

10

3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

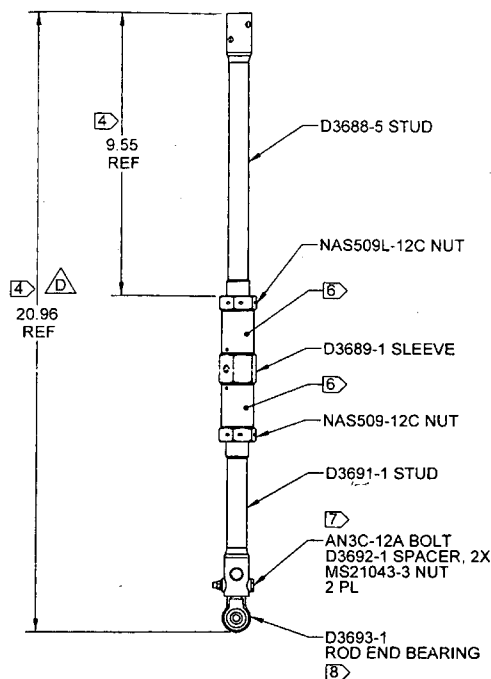
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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31999 MLC
12/03/19

D3684-045 INBOARD LEG ASSEMBLY

RELEASED
2010-03-15

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.1 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO. D3684	REV. D
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	10.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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